November-28-12 2:48:48 PM

Required Date: 12/12/2012

Item ID:

D412-702-307

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

**Start Date:** 

Item Name:

Harness Assembly

28/11/2012

Start Qty: 2.00

Req'd Qty: 2.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

**Process Plan:** 

QC:

MLS

Date: \2 -1\-Z8 Tooling:

Date:

Run

Accept Reject

Oty

Date:

Tool #

Plan

Code

Insp.

Stamp

Reject

Number

Operation Sequence ID/ Set Up/ Tool ID **Work Center ID** Description **Run Hours** Draw Nbr **Revision Nbr** ICAD412-702 100 0.00 \*100\*

Date:

Small Fab Small Fab

Memo

0.00

SPC (Y/N):

Assemble as per dwg ICA D412-702 p.49

**Qty** 

110

QC5- Inspect part completeness to step on W/O

\*110\*

Memo

Quality Control

120

0.00

\*120\*

Packaging

0.00

Packaging

Identify with P/N & CHG# and pack for shipping as per PPP D412-702-307

CHG001 Location:

9 14/12 E

NCR:	/es / No				WORK ORDER NON-C	CON	1FORI	MANCE / UPI	DATE				
	ŕ							•		QA Closed:	Date:		
Work Orde	er:				DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part N	•		***	<u> </u>	Rework Scrap	$\left\{ \  ight $	Skid-tube Crosstube Machining Small Fab			Pro	Water Jet d. Eng. Coor.	Engineering Quality	
NCR No.					Use-as-is Work Order Update	Thermoforming Finishing Large Fab Composite			4	re/Packaging Supplier	Other		
Root				Descri	ption of work order update	li	nitial	Act	ion	Sign &			
Cause	Date	Step	Qty	C	or Non-conformance	Chi	ief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data													
quip/Tooling						ļ							
Operator	_												
Material	_												
Setup	<u> </u>												
Other	_												
Process	_												
Supplier													
Training	_												
Unapproved		<u> </u>	IL			<u>Ι</u> Δ1117	r cate	SORV		<u> </u>	<u>i                                    </u>	1	
Landir	ng Gear				General		CAIL	JONI			<u>.</u>		
[	Bending				Bend	$\Box$	Ġrain			Ovalized		Pressure/Forced	
	Centre No	ot Concer	ntric to C	o/s 🗀	BOM/Route	-	Hardwa	re	<del></del>	Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	П	Inspecti	on Incomplete		Part Incorre	<del> </del>	Weld	
	Crushed/Crimped.				Burrs	П	Instruct	ions Incomplete/L	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled	
Ì	Cuffs				Contamination	П	Mainte	nance		Part Moved		_	
	Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	_	
	Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other	
	Ripples in	Bend			Drill Holes		Offset		_				
	Torque W	aves in E	xtrusion		Drawing		Out of C	Calibration					
	Turning S	equence			Finish		Out of S	iequence					

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-28-12 2:48:48 PM Item ID: D412-702-307 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Harness Assembly **Start Date:** 28/11/2012 Start Qty: 2.00 **Cust Item ID: Required Date:** 12/12/2012 **Req'd Qty: 2.00 Customer:** Reference: Run Start **Process Plan: Approvals:** Date: **Tooling:** Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Qty Number Stamp Code 130 QC21- Final Inspection - Work Order Release 0.00 12-11-29 \*130\* QC 0.00 Memo Quality Control

										DQA:	Date:	
NCR: Y	res / No				WORK ORDER NON-	COI	VFOR	MANCE / UPE	DATE	QA Closed:	Date	
<del></del> .												<del></del>
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part No.  NCR No.					Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update	T	nitial	Acti	ion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data											•	·
Equip/Tooling		}										
Operator												
Material												
Setup												
Other												
Process												
Supplier							:					
Training												
Unapproved									<b>S</b> .			
					F	AUL	T CATE	GORY				
Landin	ng Gear				General					_		_
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (	D/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
[	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
[	Crushed/	Crimped.			Burrs		Instruct	ons Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs		•		Contamination		Mainte	nance		Part Moved		_
	Heat Trea	it -			Countersink		Mislabe	led		Positioned Wrong		
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		Offset			•		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

November-28-12 2:48:51 PM

Work Order ID: 93985

Parent Item:

D412-702-307

\*93985\*

\*D412-702-307\*

Parent Item Name: Harness Assembly

**Start Date: 28/11/2012** 

Start Qty: 2.00

**Required Date: 12/12/2012** 

Required Qty: 2.00

IPP Rev: A new issue DD 10.04.30 verified: EC

Comments:	PP Rev:A new iss	ue DD 10.04.30	verifie	i:EC									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date S Issued	tatus
D3573-3		Manufactured	No			100	Each	9.0000	1	2 .	0/	11	
*D3573-3*									**	4	2/2	14/28	
				Locatio	<u>on</u>	Loc (	<u>Oty</u>	Loc Code			·	•	
				GA			9				_		
					80485		4			_d_	_		
D4088-041		M. C . 1	Na		87626	100	5	45.0000	. –		_		
	1 4 4h	Manufactured	No			100	Each	47.0000	1	2	()/1		
*D4088-04 Shoulder Harness	L1*								**			12/11/	28
				Locatio	<u>n</u>	Loc (	<u>Oty</u>	Loc Code				, ,	
				ST264			25 .				_		
					87300		17				_		
					90248		8				_		
				st268	91437		22 22			~	<b>-</b> .		
MS24693-S272		Purchased	No		91437	100	Each	113.0000		•			/ ,
	0070*	ruichaseu	110			100	Lacii	113.0000	**	8 .		(	
*MS24693	-5///								~ ~	<	LE -	10/11	128
Sciew			-	Locatio	_	Loc C	N4					//	
				GA	<u>u</u>			Loc Code					
				UA	118352		101 101			8	_		
				ST288			12		_		_		
				2.230	116391		11		_		_		
					116737		1			· ·	-		
					•								

										DQA:	Date:		
NCR: Y	es / No				WORK ORDER NON-C	CON	NFOR	MANCE / UPDATE				····	
										QA Closed:	Date:		
144 O					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Orde	er:				Rework	1		Skid-tube Crossi	tubo [	1	Water Jet	Engineering	
Part N	lo				Scrap	1	!	Machining Small	_	Pro	d. Eng. Coor.	Quality	
raitiv				<del></del>	Use-as-is		noforming Finis		4	re/Packaging	Other		
NCR N	lo.				Work Order Update	1	1110111	Large Fab Compo	~ <b>—</b>	1100,510.	Supplier	1 1 1	
						'						<b>.</b>	
Root				Descri	ption of work order update	lı	nitial	Action		Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Chi	ief Eng	Description		Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling		]			•		:						
Operator													
Material													
Setup	_		,										
Other	_												
Process	_												
Supplier	_	l											
Training													
Unapproved		1	L		-		T CATE				<u> </u>		
			<del>.</del>	<u></u>	General FA	AUL	T CATE	GURY					
Landin	ng Gear				Bend	П	Grain		Г	Ovalized		Pressure/Forced	
}	Bending	- <b>+</b> C		o/s	BOM/Route	-			-	4	talaranaa	╡	
}	Centre No	ot Concer	itric to	<sup>0/3</sup>  -	1	Н	Hardwa		$\vdash$	Over/Under	<u> </u>	Temperature/Cure	
	Cracks	Crimaad		<u> </u>	Broken/Damaged	$\vdash$		on Incomplete	-	Part Incorred	<del></del>	Weld Wrong Stock Pulled	
·	Crushed/0	crimpea,		-	Burrs Contamination	$\vdash$	Mainte	ions Incomplete/Unclear		Part Lost/Mi Part Moved	22111g	Tantous prock Lause	
}	Heat Trea	.+			Countersink		Mislabe		-	Positioned V	Vrong		
	Inearited	I C		1	Logiticishik	1 1	MINISTANE	icu	l	Trositioned v	VIONE		

Misread

Out of Calibration

Outside Dimensions

Out of Sequence

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

## **Picklist Print**

November-28-12 2:48:51 PM

Work Order ID: 93985

D412-702-307

\*AN960.ID10LL\*

Parent Item Name: Harness Assembly

\*93985\*

\*D412-702-307\*

**Start Date:** 28/11/2012

**Required Date:** 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

AN960JD10LL

Parent Item:

Purchased

No

100

Each

3,308.000

\*\*

Location ST337A

> 19085 19600

Loc Code

MS21042L3

Purchased

No

100

3160 Each

3308

148

Loc Qty

1,481.000

\*\*

\*MS21042L3\*

Nut

Location	Loc Qty	Loc Code
ST300	225	
117885	32	
119017	55	
119075	138	
ST314	557	
123265	557	
ST315	467	
122452	467	
ST317	232	
122141	232	

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-CONFORMANCE / UPDATE							
										QA Closed:	Date:	
Work Orde	ar:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGC					Rework		Skid-tube	Crosstube	7	Water Jet	Engineering	
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
, NCR N	lo				Work Order Update	]		Large Fab	Composite		Supplier	
		<b>,</b>										
Root					ption of work order update	1	Initial		tion	Sign &	_	
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling	_											
Operator										ļ		
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved									·			
						AUL	T CATE	GORY				
Landin	g Gear			_	General		1			7	_	1
	Bending				Bend		Grain			Ovalized		Pressure/Forced
L	Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged		Inspecti	on Incomplete		Part Incorred	t	Weld
Ĺ	Crushed/	Crimped.			Burrs		Instructi	ons Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence
Wave/Twist in Tube

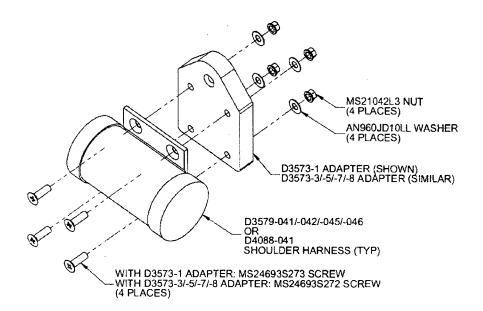
Ripples in Bend

Torque Waves in Extrusion

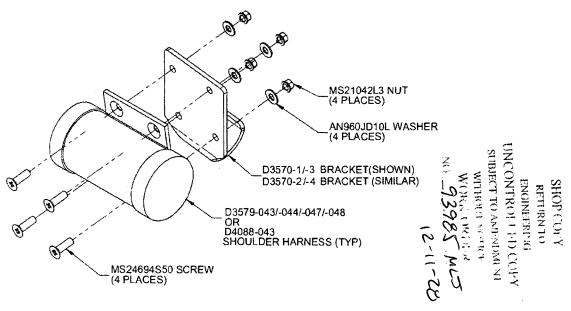
Drill Holes

Drawing

Finish



<u>DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B OR -301/-303/-305/-307/-309/-315/-317 HARNESS ASSEMBLIES</u>



DETAIL 'L' D412-702-111A/-111B/-113A/-113B OR -311/-313/-321/-323 HARNESS ASSEMBLIES

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